

Date: Friday, 27/10/2006 2:43:06 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 29206		
Estimate Number	: 10469		
P.O. Number	: N/A	Part Number	: D3391023
This Issue	: 27/10/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3391 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28339	Drawing Revision	: E
		Material	: N/A
Written By	: _____	Due Date	: 30/11/2006
Checked & Approved By	: _____	Qty:	1
Comment	: Est. A 05.10.20 New Issue KJ/EC	Um:	Each
	: Est. B 06.02.10 ECN773 dwg rev.D EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description
1	D2500-1-100	Extrusion

Batch

B24593 DP 7-1-3

①

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375"

7-Rmove .030" from Fwd indexing Ridge as per Dwg D3391

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

9-Deburr

10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J"

012-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

DP 7-1-3

DP 7-1-3

DP 7-1-8

W/O:			WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13-Open .375" holes to .438"

14-Deburr and blow out all chips from inside tube

DP-1-B

①

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/08

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Job 07-01-08

①

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-01-08

6.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D3389-1

Web

27656
m 102671
07-02-01

A/R

Sikaflex-241/-291

Sikaflex expire date:

Start: *3:00* Time: *3:30*

Finish: *07-02-01* Time: *3:00*

07-01-08

①

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

DP/ JB

7-1-B

①

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/02/24

①

W/O:			WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 13 Date: 07/02/27

QA: N/C Closed: _____ Date: _____

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Job Number: 29206

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S40 07/02/09 (1)

10.0

NAS1330C3KB116

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

20

NAS1330C3KB116

Insert

M119349

~~B100732~~

m/f a.m 07/02/24 (1)

11.0

NAS1330C3KB166

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

B100732 m/f a.m 07/02/24 (1)

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install inserts as per Dwg D3391

m/f a.m 07/02/24 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

0702-26 (1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A n 30260A

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/24 (1)

Job Completion



n 07/02/26

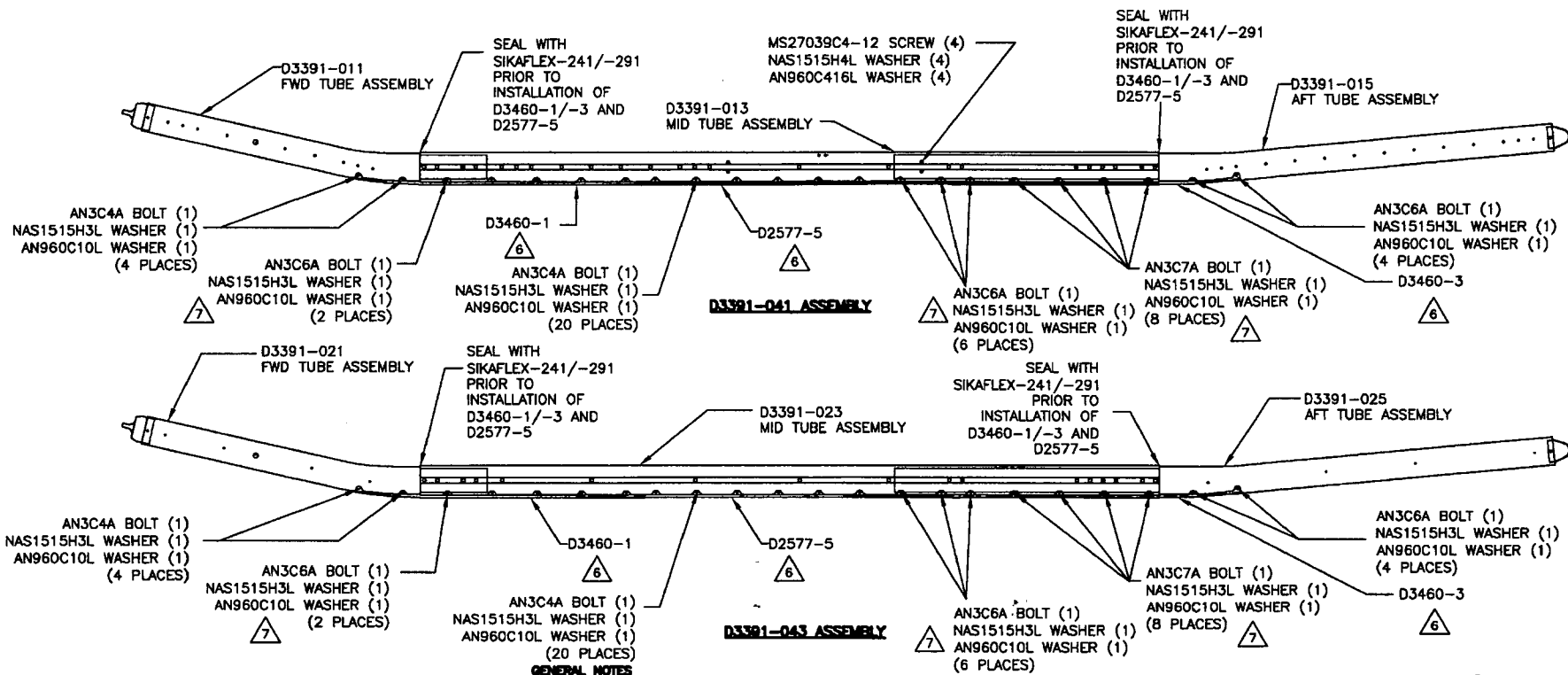
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D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

- GENERAL NOTES**
- 1) ALL DIMENSIONS ARE IN INCHES.
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
 - 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
 - 6) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
 - 7) DO NOT TORQUE, HAND TIGHTEN ONLY D

REFERENCE ONLY

RELEASED

06-05-03

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E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	<input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>
DATE	06.04.25	DRAWING NO. D3391
		TITLE 412 FLOAT SKIDTUBE
		REV. E SHEET 1 OF 5 SCALE NTS

DART DART AEROSPACE USA, INC.
PORT HAZARD, MA

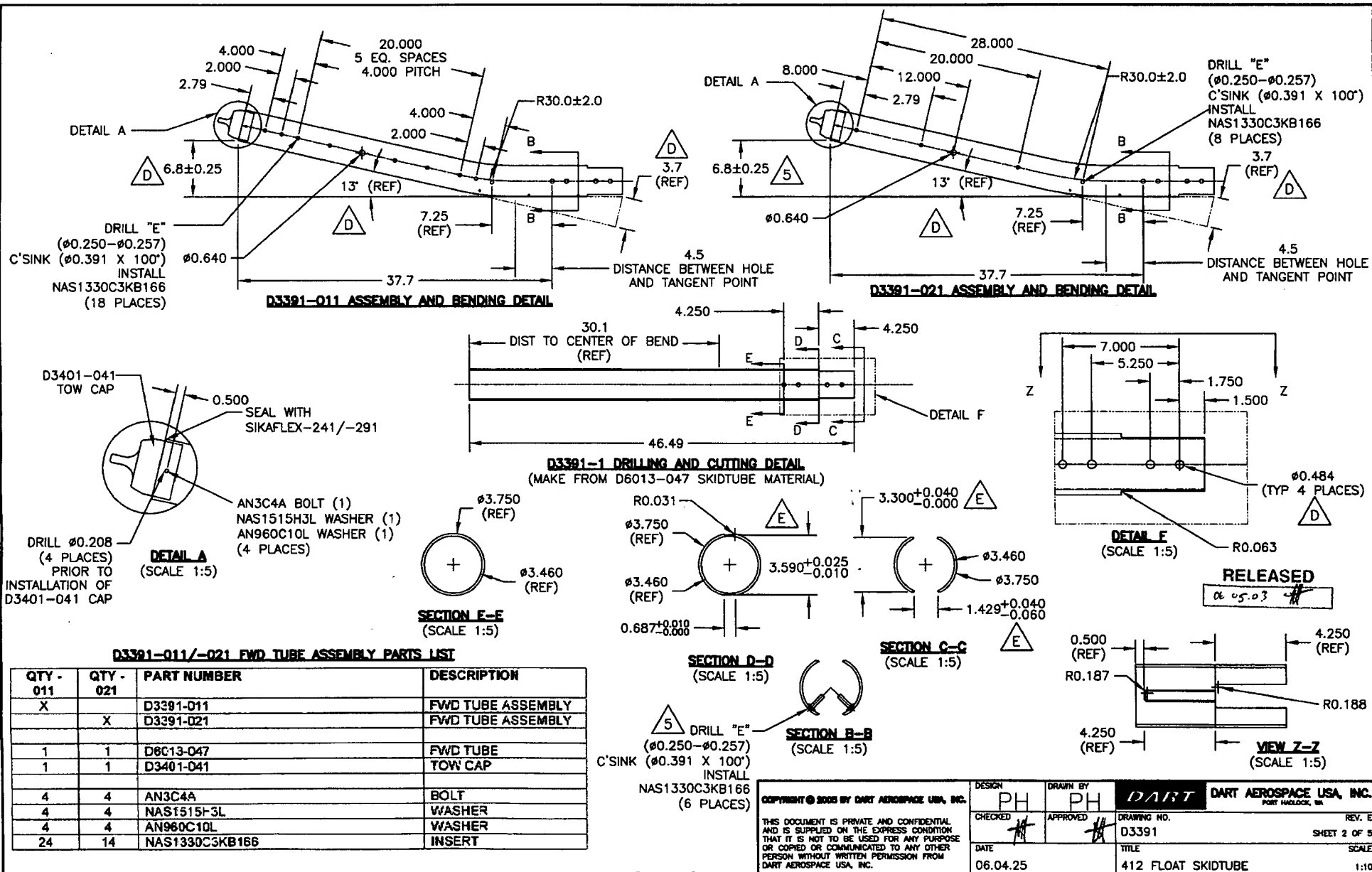
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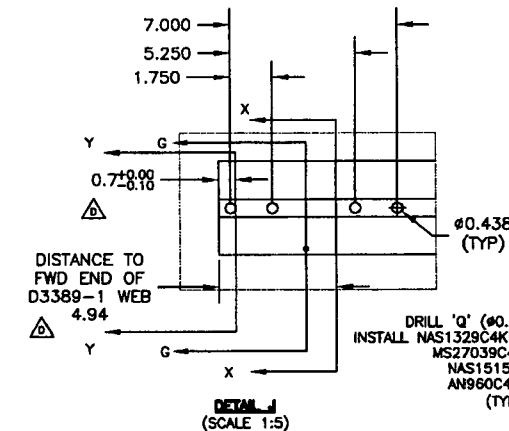
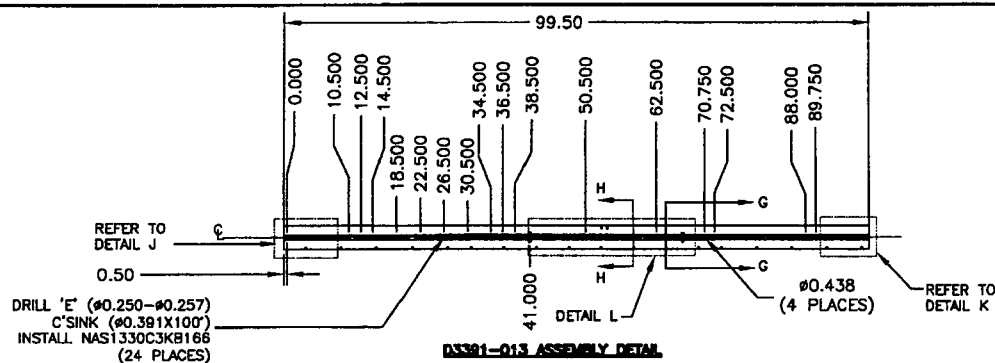
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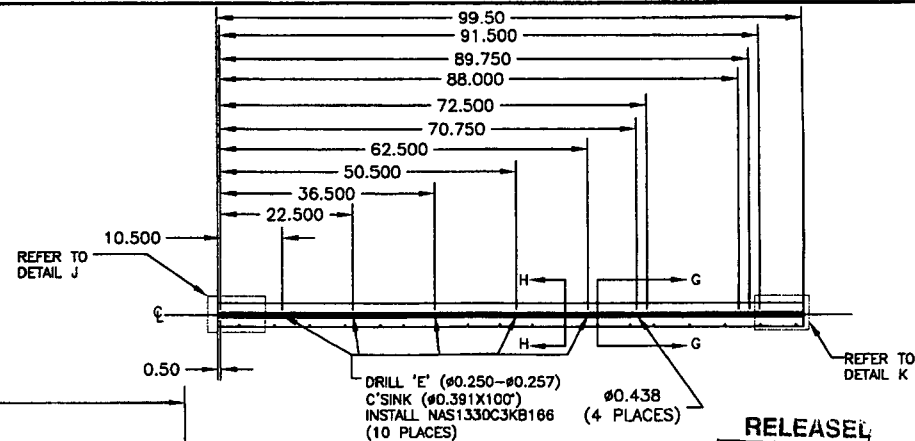


D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

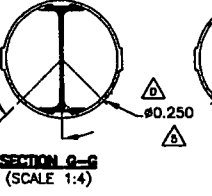
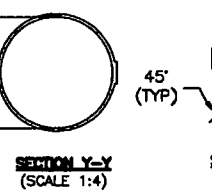
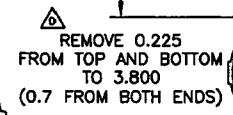
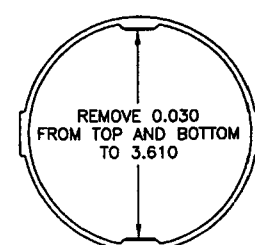
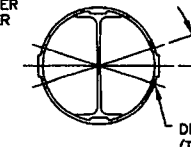
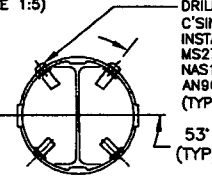
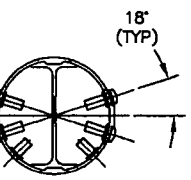
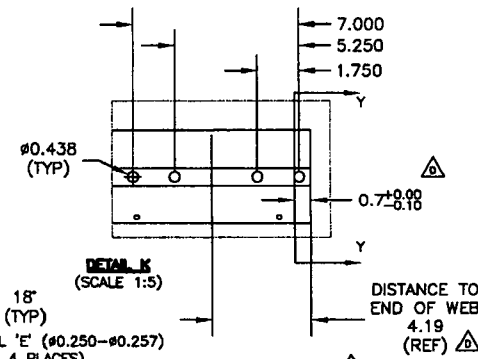
QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015



RELEASED
06-05-06



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED #	APPROVED #		DRAWING NO. D3391
DATE 06.04.25		TITLE 412 FLOAT SKIDTUBE		SCALE 1:20	

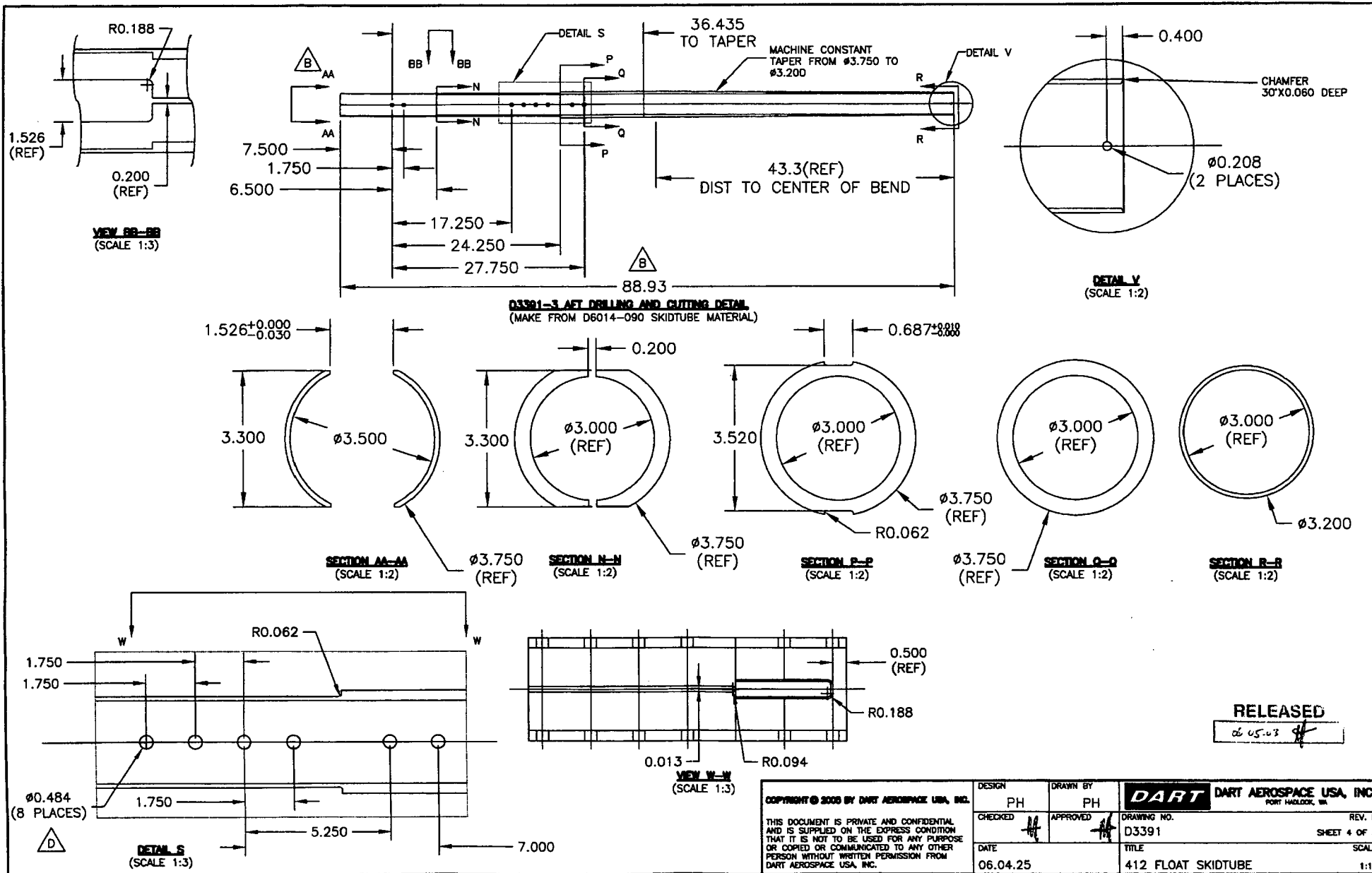
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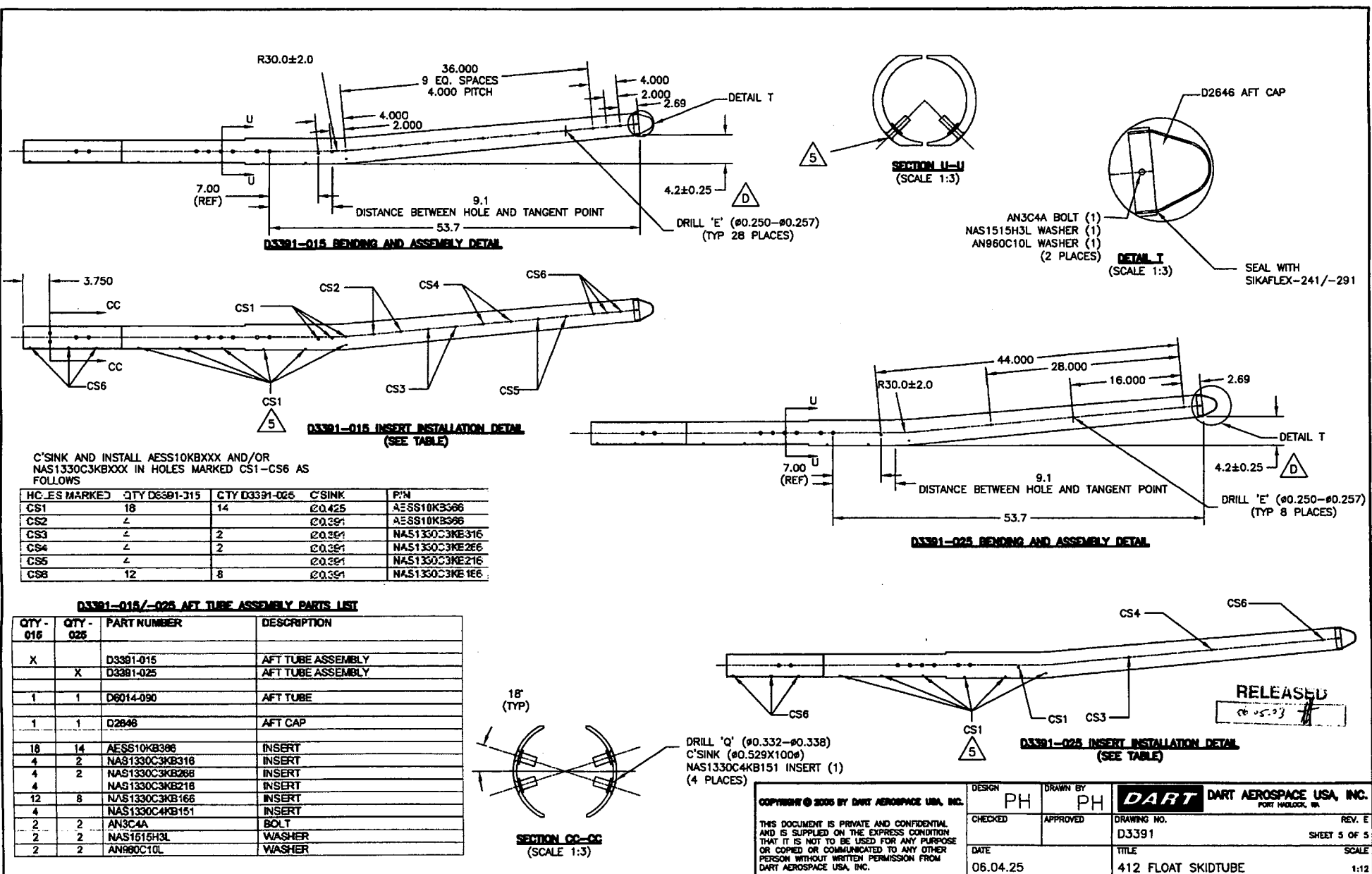
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